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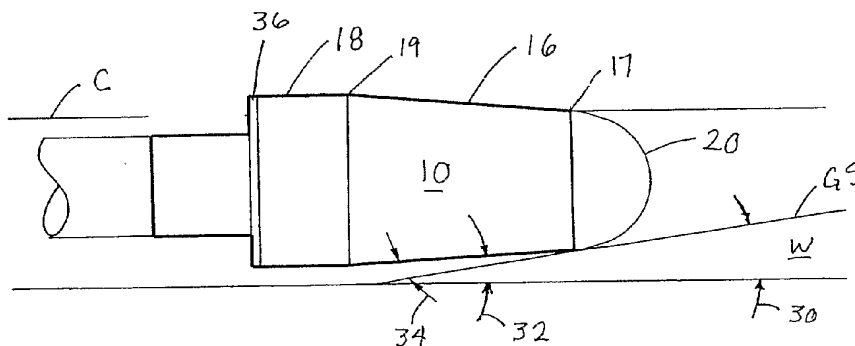
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(54) Title: SINGLE MILL CASING WINDOW CUTTING TOOL



(57) Abstract: An apparatus for cutting a window in a casing pipe in a well, having only a single mill (10) with full gage primary cutting inserts (22) of a very hard, highly wear resistant, material. The primary inserts can be protected from damage by forming each blade (14) on the mill with an outside edge profile having a shallower angle than the angle of the whipstock which is used to guide the mill through the casing, preventing the primary inserts from riding directly on the whipstock. The primary inserts on each blade can be further protected from damage by a row of secondary inserts (24) of a relatively more durable material, arranged behind each row of primary inserts, or by a full diameter buffer section (36) of mill body or blade.

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## Single Mill Casing Window Cutting Tool

### BACKGROUND OF THE INVENTION

Field of the Invention - This invention is in the field of methods and apparatus used to cut an exit or side window in a casing, downhole in a well bore, typically for the purpose of drilling a lateral well bore angled away from the main bore.

Background Art - Often, it is desired to cut a window in a downhole well casing in an oil or gas well, for the purpose of exiting the casing, to drill a lateral well bore off of the main bore. Typically, multiple mills are used to form such a window having the desired full gage diameter. Often, three separate mills are used, as shown in Figure 1.

The downhole direction will be shown to the right herein, and the uphole direction to the left, but it should be understood that the borehole could be oriented vertically, horizontally, or anywhere in between. Further, it should be understood that, as used herein, the term "full gage" signifies a window having a diameter which is at least 96% of the full inside diameter of the casing which is being exited. Since the window will have an elliptical shape, the lesser or transverse diameter of such a full gage window will be at least 96% of the full inside diameter of the casing. The greater or longitudinal diameter of the window may be even greater than the inside diameter of the casing. Finally, when the term "separate mills" is used herein, it should be understood that two groups of cutting inserts separated by a substantial axial distance can be considered to constitute two "separate mills". For example, in some such mills, an axial distance of greater than one inch between groups of inserts could be considered substantial.

Often, the three mills that are typically used to cut such a window are all mounted on a work string WS together, one above the other. The lower or lead mill LM penetrates the casing wall C; then it is followed by the upper mills, commonly referred to as string mills or backup mills B1, B2. In such an apparatus, all three mills LM, B1, B2 typically have the same outer diameter, at least in their original condition. However, by the time the lead mill LM penetrates the casing C, it will usually have a slightly smaller diameter than it originally had, because of damage to the cutting inserts, resulting from severe vibration and impact against the casing C and the

whipstock W. The string mills above it are then required to pass through the window in order to open it up to a substantially full gage diameter.

The lead mill LM cuts a relatively small window in the casing C as it is guided therethrough by the guide surface GS of a whipstock W. Rotation of the work string WS then continues as the second mill B1, and eventually the trailing mill B2, pass through the window, as shown in Figure 2. Each mill slightly enlarges the window as it passes through. Typically, at least two and often three mills must be used, because the cutting inserts on the lead mill LM and even on the second mill B1 often deteriorate rapidly, with the result that the lead mill LM and the second mill B1 lose diameter during the window cutting process. This loss in mill diameter results in the cutting of a window that is slightly smaller than the original diameter of the mills. The mills can not have an original diameter that is larger than the full casing gage, of course. So, the second and third mills B1, B2 must be used to bring the casing window diameter up to full gage.

This typical apparatus having three separate mills on the work string suffers from several disadvantages. First, it is quite costly, because three mills, or at least three spaced apart groups of cutting inserts, are required. Second, the three mills are typically mounted together in a longitudinal arrangement, with the arrays of cutting inserts on the different mills being axially separated by a distance of greater than one inch. This creates a relatively long three mill assembly with a rigid axis. As a result, the apparatus can experience a substantial amount of vibration. Third, because of the long rigid axis of the three mill assembly, it is difficult to turn the mill in a direction away from the whipstock after forming the window and exiting the casing.

#### BRIEF SUMMARY OF THE INVENTION

The present invention can include a method and apparatus for cutting a substantially full gage casing exit window with a single mill, rather than multiple mills. The mill of the present invention can have multiple blades, with cutting inserts mounted on the blades. The cutting inserts can be of a very hard, wear resistant, material, such as polycrystalline diamond. Although very hard, such inserts can be susceptible to damage from vibration and impact against the casing and especially against the hard guide surface of the whipstock. The original condition of the

relatively hard cutting inserts can be preserved by providing a secondary set of relatively more durable inserts behind each row of the harder primary cutting inserts. These secondary inserts provided for the purpose of protecting the primary cutting inserts can be made of a relatively more durable material such as tungsten carbide.

To further counteract the susceptibility of the cutting inserts to damage, each blade can have a tapered or tapering section which tapers outwardly from its leading end toward its trailing end, with the angle of this taper being less than the angle of the wedge or guide surface on the whipstock with which the mill is used. The trailing end of the blade can be at substantially full gage diameter. A substantially full gage section of the blade above the tapered section can also be provided. A narrow band of the mill body or the blades can also be provided as a buffer section, preferably in the full gage section, with this narrow buffer section being at the full diameter of the mill body, to protect the cutters on the full gage section from shock or impact.

As the mill progresses downwardly along the whipstock, because of the difference in the blade taper angle and the whipstock wedge angle, only the nose of the mill rides along the whipstock, with the cutting inserts on the tapered and full gage sections of the blade being angled away from the whipstock. Keeping the tapered and full gage sections of the blade spaced away from the whipstock preserves the condition of the cutting inserts along the tapered and full gage sections. This causes the mill to substantially maintain its full gage diameter all the way through the casing window, thereby alleviating the need for using one or more backup mills to establish a full gage window opening.

The novel features of this invention, as well as the invention itself, will be best understood from the attached drawings, taken along with the following description, in which similar reference characters refer to similar parts, and in which:

#### BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

Figure 1 is a schematic view of a prior art three mill assembly;

Figure 2 is a schematic view of the assembly shown in Figure 1 as it penetrates the casing wall;

Figure 3 is a side elevation view of the mill of the present invention; and

Figure 4 is a schematic view of the mill shown in Figure 3, as its nose moves along the whipstock and the tapered and full gage portions of the mill penetrate the casing wall.

#### DETAILED DESCRIPTION OF THE INVENTION

As shown in Figure 3, the mill 10 of the present invention includes a mill body 12, and a plurality of blades 14 spaced around the periphery of the mill body 12. The mill 10 also has a substantially rounded nose section 20, which can be formed from the leading ends of the blades 14, or which could be formed on the mill body 12 itself, without departing from the present invention. A plurality of primary cutting inserts 22 are mounted on the outer surface of each blade 14, oriented to cut through a casing as the mill 10 is rotated by the work string WS. It can be seen that the outermost edges of the primary cutting inserts 22 together establish a contour which is radially outside the outer contour of the blades 14 themselves. The primary cutting inserts 22 can be formed of a very hard material such as polycrystalline diamond, for maximum wear resistance in cutting through metal. A plurality of similar primary nose inserts 26 can be mounted on the surface of the nose section 20.

While such hard materials are optimal for wear resistance, they are often less than optimal for durability, sometimes breaking prematurely under impact against hard surfaces. To protect the primary cutting inserts 22 from impact damage, a plurality of secondary inserts 24 can also be mounted on the outer surface of each blade 14, positioned behind the plurality of primary cutting inserts 22, relative to the rotational direction of the mill 10. The rotational direction of the mill illustrated in Figure 3 is clockwise when viewed from the uphole end. The secondary inserts 24 can be formed of a material such as tungsten carbide, which is relatively more durable than the material of the primary inserts 22. Since the secondary inserts 24 are principally for the purpose of protecting the primary cutting inserts 22 from being damaged by impact against the casing or against the whipstock, they are placed behind the primary inserts 22 in a rotational sense, leaving the primary inserts 22 exposed to rotational contact with the casing for cutting purposes. However, the secondary inserts 24 are mounted with their outermost edges lying on substantially the same contour established by the outermost edges of the primary inserts 22, thereby

absorbing impacts to protect the primary inserts 22. A plurality of similar secondary nose inserts 28 can be mounted on the surface of the nose section 20, behind the primary nose inserts 26 in a rotational sense.

The blades 14 are shown as substantially elongated blades having a slightly helical shape curving around the mill body 12, but they could have other shapes without departing from the present invention. Importantly, each blade 14 has a tapered section 16 which has an outer edge that tapers outwardly from a point near its leading end 17 toward a point near its trailing end 19, as seen more easily in Figure 4. The diameter established by all of the trailing ends 19 of these tapering sections 16 of the blades 14 can be a substantially full gage diameter, relative to the inner diameter of the casing through which the mill 10 is lowered downhole.

The outer edge of the tapering section 16 of each blade 14 lies along a contour which is at an acute angle relative to the longitudinal axis of the mill body 12. It can be seen that, since the blades shown are helical, their outer edges lie along a substantially conical contour, which can have a slight axial curve or bulge, or which can be a straight conical contour. In either case, the important feature is that the outer edge of the tapered section 16 of the blade 14 has an increased radial distance from the longitudinal axis of the mill body 12 as the blade section 16 tapers outwardly from its leading end 17 toward its trailing end 19, and that this angle of taper bears a particular relationship to the angle on the whipstock, as discussed below.

Each blade 14 also can have a substantially full gage section 18 at its trailing end, with the full gage sections 18 having outside edges which are parallel to and equidistant from the longitudinal axis of the mill body 12. That is, the full gage sections 18 of the blades 14 establish a substantially cylindrical contour which is coaxial with the longitudinal axis of the mill body 12. Each such outer edge of a full gage section 18 could be parallel to the longitudinal axis, or it could be slightly helical, without departing from the present invention. Further, the full gage section 18 could be formed on a substantially cylindrical surface of the mill body 12 itself, rather than on the blades 14, without departing from the present invention. Finally, a narrow band of the mill body 12 or blade 14 can be provided as a buffer section 36 on the full gage section 18, to act as a shock absorber, to further protect the primary cutting inserts 22 in the full gage section 18 from impact damage. The axial dimension of

this narrow buffer section 36 would preferably be at least a quarter inch. The outermost diameter of this buffer section 36 would preferable be at the full diameter of the mill 10.

For ease of illustration, the mill 10 is shown in Figure 4 as having its longitudinal axis parallel to the longitudinal axis of the casing C and the longitudinal axis of the whipstock W, even though in actual use, the longitudinal axis of the mill 10 will likely be slightly angled relative to the longitudinal axis of the casing C. The upper end of the whipstock W has a wedge or angled guide surface GS, which is azimuthally oriented in the desired direction for exiting the casing C. The guide surface GS is angled at a first acute angle 30 relative to the longitudinal axis of the casing C. The tapered section 16 of each blade 14 of the mill 10 is angled at a second acute angle 32 relative to the longitudinal axis of the mill body 12. The second angle 32 is less than the first angle 30 by a third angle 34.

As the mill 10 is lowered through the casing C, the nose section 20 of the mill 10 will contact the guide surface GS of the whipstock W. The fact that the second angle 32 of the blade taper is less than the first angle 30 of the whipstock causes the outer edges of the primary cutting inserts 22 on the tapered sections 16 of the blades 14 to be angled away from the hard guide surface GS of the whipstock W. It has been found that for best effect, the magnitude of the third angle 34 should be between about 3 degrees and 10 degrees, to insure that the primary inserts 22 on the tapered sections 16 of the blades 14 will be spaced away from the whipstock guide surface GS, even when the longitudinal axis of the mill 10 is slightly angled relative to the longitudinal axis of the casing C.

As the mill 10 is rotated by the work string WS, the nose section 20 of the mill 10 moves downwardly along the guide surface GS, causing the primary and secondary inserts 22, 24 on the full gage section 18 and the primary and secondary inserts 22, 24 on the tapered blade sections 16 to contact and mill through the wall of the casing C. Only the nose section 20 of the mill 10 contacts the whipstock guide surface GS.

While this milling is taking place, it can be seen that the presence of the secondary inserts 24 and the narrow band 36 of body or blade protects the primary inserts 22 from being unduly damaged by impact against the casing C. It can also be seen that the existence of the third angle 34 keeps the primary inserts 22 from

contacting the whipstock guide surface GS, thereby protecting the primary inserts 22 from undue damage. Further, the use of a single mill according to the present invention minimizes the rigid axial length of the tool and minimizes the vibration experienced, which further reduces the incidence of impact damage to the primary inserts 22. This combined protection of the primary inserts 22 allows the mill 10 to maintain the substantially full gage diameter of the outer edges of the primary inserts 22 near the trailing ends of the tapered sections 16 of the blades 14 and the substantially full gage diameter of the outer edges of the primary inserts 22 on the full gage section 18 of the mill 10. Maintaining this substantially full gage diameter allows the mill 10 to completely form a substantially full gage window in the casing wall, without the need for backup mills.

Eventually, the primary and secondary inserts 26, 28 on the nose section 20 also contact and mill through the casing C. It can be seen that the presence of the secondary nose inserts 28 protects the primary nose inserts 26 from being unduly damaged by impact against the casing C or the guide surface GS of the whipstock W.

It is to be understood that this disclosure is merely illustrative of the presently preferred embodiments of the invention and that no limitations are intended other than as described in the appended claims.



## CLAIMS

I claim:

1. A mill for cutting a window in a well casing, comprising:  
a mill body adapted for mounting on a work string for rotation downhole in a well casing;  
a plurality of blades formed on said mill body;  
a row of primary cutting inserts mounted on each said blade; and  
a row of secondary inserts mounted on each said blade behind said row of primary inserts relative to the direction of rotation of said mill;  
wherein said primary cutting inserts are formed of a relatively harder material than said secondary inserts, and said secondary inserts are formed of a relatively more durable material than said primary inserts.
2. The mill recited in claim 1, wherein said primary cutting inserts are formed of polycrystalline diamond material.
3. The mill recited in claim 2, wherein said secondary inserts are formed of tungsten carbide material.
4. The mill recited in claim 1, wherein said secondary inserts are more fracture resistant than said primary inserts.
5. The mill recited in claim 1, further comprising:  
a tapering section on each said blade, said tapering section having an outside edge profile formed along a first contour lying at an acute angle relative to the longitudinal axis of said mill body; and  
a substantially full gage section on said mill above said tapering sections of said blades, said substantially full gage section having an outside profile formed along a second contour lying substantially parallel to the longitudinal axis of said mill body.

6. The mill recited in claim 5, wherein a first group of said primary cutting inserts on said tapering section of each said blade have their outermost edges lying substantially along a third contour tapering outwardly from a leading end of said tapering section of each said blade to a substantially full gage diameter near a trailing end of said tapering section of each said blade.

7. The mill recited in claim 6, wherein a second group of said primary cutting inserts on said substantially full gage section have their outermost edges lying substantially along a fourth, substantially cylindrical, contour coaxial with the longitudinal axis of said mill body, said fourth cylindrical contour being at substantially full gage diameter.

8. The mill recited in claim 5, further comprising a nose section on said mill below said tapering sections of said blades, said nose section having a rounded contour substantially forming the lower end of said mill.

9. The mill recited in claim 8, further comprising a plurality of primary cutting inserts on said nose section.

10. The mill recited in claim 1, further comprising a buffer section on said mill, said buffer section having an outer diameter substantially at the full diameter of said mill, said buffer section being positioned to protect at least one of said primary cutting inserts at substantially full gage from impact damage.

11. The mill recited in claim 10, wherein said buffer section comprises a substantially full mill diameter section of said mill body.

12. The mill recited in claim 10, wherein said buffer section comprises a substantially full mill diameter section of each of said blades.

13. An apparatus for cutting a window in a well casing, comprising:  
a whipstock adapted to be mounted downhole in a well casing at a location where a casing window is to be cut, said whipstock having a wedge at its upper end, said wedge having a guide surface formed at a first acute angle relative to the longitudinal axis of said casing;  
a mill having a mill body adapted for mounting on a work string for rotation downhole in a well casing;  
a plurality of blades formed on said mill body; and  
a tapering section on each said blade, said tapering section having an outside edge profile formed along a contour lying at a second acute angle relative to the longitudinal axis of said mill body, said second acute angle being less than said first acute angle.
14. The apparatus recited in claim 13, wherein said second acute angle is less than said first acute angle by between 3 and 10 degrees.
15. The apparatus recited in claim 13, further comprising:  
a row of primary cutting inserts mounted on each said blade; and  
a row of secondary inserts mounted on each said blade behind said row of primary inserts relative to the direction of rotation of said mill;  
wherein said primary cutting inserts are formed of a relatively harder material than said secondary inserts, and said secondary inserts are formed of a relatively more durable material than said primary inserts.
16. The apparatus recited in claim 15, further comprising:  
a tapering section on each said blade, said tapering section having an outside edge profile formed along a first contour lying at an acute angle relative to the longitudinal axis of said mill body; and  
a substantially full gage section on each said blade above said tapering section, said substantially full gage section having an outside edge profile formed along a second contour lying substantially parallel to the longitudinal axis of said mill body.
17. The apparatus recited in claim 16, wherein a first group of said primary cutting inserts on said tapering section of each said blade have their outermost edges lying substantially along a third contour tapering outwardly from a leading end of said

tapering section of each said blade to a substantially full gage diameter near a trailing end of said tapering section of each said blade.

18. The apparatus recited in claim 17, wherein a second group of said primary cutting inserts on said substantially full gage section of each said blade have their outermost edges lying substantially along a fourth, substantially cylindrical, contour coaxial with the longitudinal axis of said mill body, said fourth cylindrical contour being at substantially full gage diameter.

19. The apparatus recited in claim 16, further comprising a nose section on each said blade below said tapering section, said nose section having a rounded contour substantially forming the lower end of said mill.

20. The apparatus recited in claim 19, further comprising a plurality of primary cutting inserts on said nose section of each said blade.

21. A method for cutting a window in a well casing, comprising:  
mounting a whipstock downhole in a well casing at a location where a casing window is to be cut, said whipstock having a guide surface at its upper end, said guide surface being formed at a first acute angle relative to the longitudinal axis of said casing;  
providing a mill having a mill body and a plurality of blades formed on said mill body, with a tapering section on each said blade, said tapering section having an outside edge profile formed along a contour lying at a second acute angle relative to the longitudinal axis of said mill body, said second acute angle being less than said first acute angle;  
lowering said mill into said well casing on a work string, until the nose of said mill contacts said whipstock guide surface, with said tapered sections of said blades angled away from said whipstock guide surface;  
rotating said mill with said work string to cut a window through said casing while maintaining said tapered sections of said blades angled above said whipstock guide surface.

22. The method recited in claim 21, further comprising:  
providing a substantially full gage section on each said blade above said tapering section, said substantially full gage section having an outside

edge profile formed along a second contour lying substantially parallel to the longitudinal axis of said mill body; and  
continuing to rotate said mill with said work string as said substantially full gage section passes through said window, thereby creating a substantially full gage window with said mill.

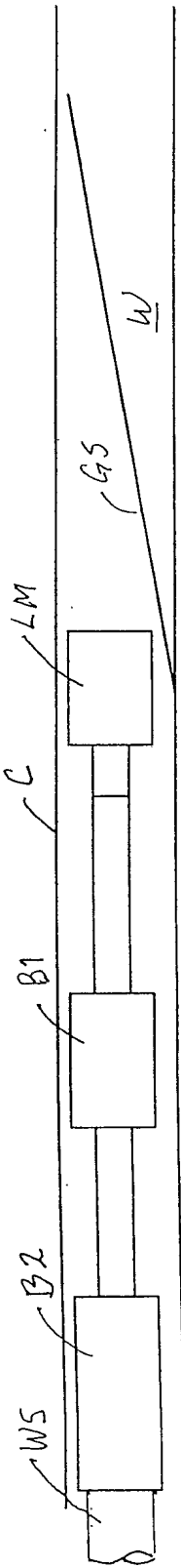


FIG. 1 (PRIOR ART)

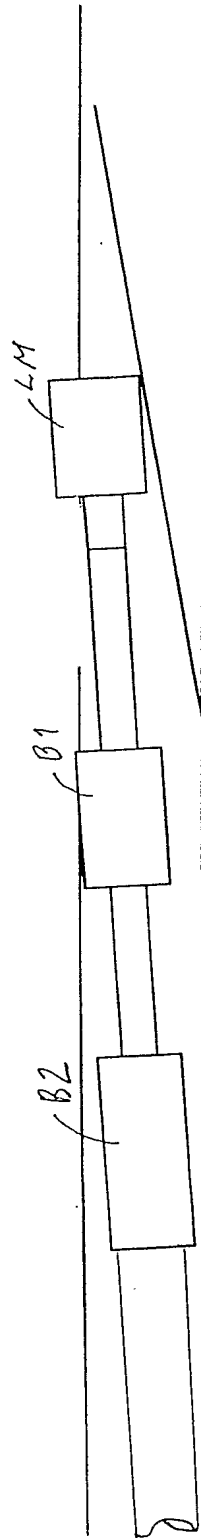


FIG. 2 (PRIOR ART)

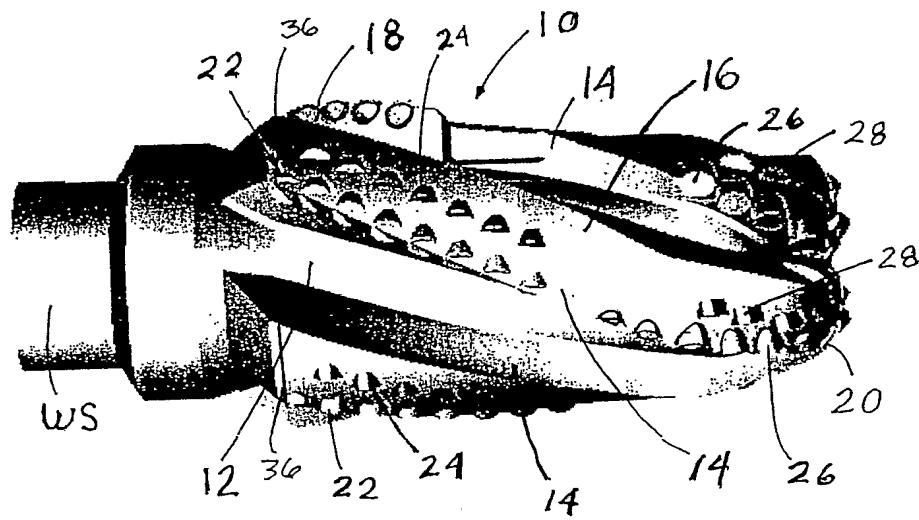


FIG. 3

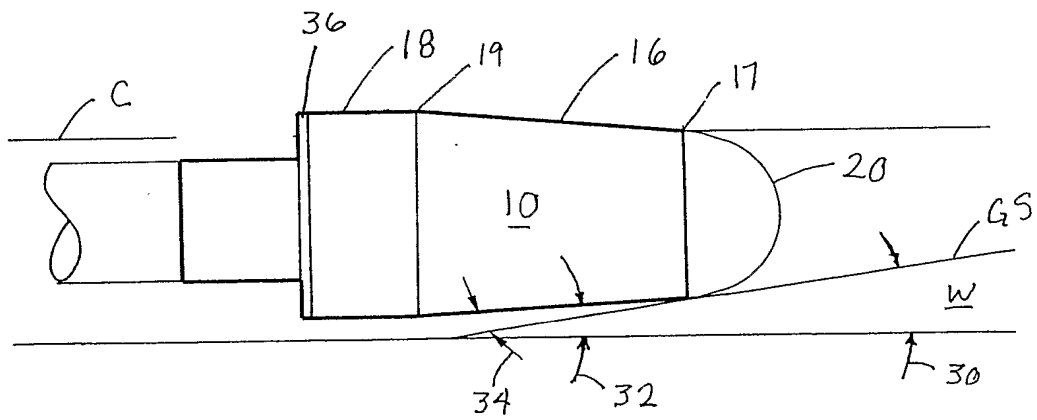


FIG. 4

## INTERNATIONAL SEARCH REPORT

International Application No  
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## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 E21B10/56 E21B29/06 E21B7/06

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 E21B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EP0-Internal

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2001/035302 A1 (DESAI PRAFUL C ET AL) 1 November 2001 (2001-11-01) paragraphs [0001], [0008], [0012], [0013], [0027], [0028], [0030], [0047], [0048], [0060]; figure 2	1-8
Y	-----	9
Y	EP 1 236 861 A (VAREL INTERNATIONAL, INC) 4 September 2002 (2002-09-04) paragraphs [0006], [0007], [0010]; figures 1,2	9
A	US 5 979 571 A (SCOTT ET AL) 9 November 1999 (1999-11-09) the whole document ----- -/-	1-12

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

## \* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance  
 "E" earlier document but published on or after the international filing date  
 "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)  
 "O" document referring to an oral disclosure, use, exhibition or other means  
 "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention  
 "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone  
 "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.  
 "&" document member of the same patent family

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1 June 2005

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Name and mailing address of the ISA

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## INTERNATIONAL SEARCH REPORT

International Application No

PCT/US2005/000543

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 6 408 958 B1 (ISBELL MATTHEW R ET AL) 25 June 2002 (2002-06-25) the whole document -----	1-12
Y	US 6 109 347 A (FERGUSON ET AL) 29 August 2000 (2000-08-29) column 3, lines 63-65; figure 5 -----	13,14
Y	US 2003/102129 A1 (DEWEY CHARLES H ET AL) 5 June 2003 (2003-06-05) paragraphs [0022], [0023]; figure 3C -----	13,14
A	US 5 277 251 A (BLOUNT ET AL) 11 January 1994 (1994-01-11) column 9, lines 64-67; figure 9 -----	13-21
A	US 5 474 126 A (LYNDE ET AL) 12 December 1995 (1995-12-12) figure 9 -----	13-21

**INTERNATIONAL SEARCH REPORT**  
**INTERNATIONAL SEARCH REPORT**

application No.  
PCT/US2005/000543

**Box II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)**

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:  
because they relate to subject matter not required to be searched by this Authority, namely:
  
2. ☐ Claims Nos.:  
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
  
3. ☐ Claims Nos.:  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

**Box III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)**

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

**Remark on Protest**

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☒ No protest accompanied the payment of additional search fees.

## FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-12

A mill for cutting a window in a well casing having a body with a plurality of side blades formed on said mill body and rows of primary and secondary cutting inserts mounted on each side blade, the secondary inserts being mounted behind the primary inserts, wherein the primary cutting inserts are formed of a relatively harder material than said secondary inserts and said secondary inserts are formed of a relatively more durable material than said primary inserts. Further structural features regarding the geometry and the impact damage protection of the primary inserts at the level of the gage diameter are claimed in the dependent claims.

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2. claims: 13-20, 21-22

An apparatus for cutting a window in a well casing comprising a whipstock and a mill with a plurality of blades having a tapering section, wherein the acute angle of the tapering section with the longitudinal axis of the mill is less than the acute angle of the whipstock guiding surface with the longitudinal axis of the casing.

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# INTERNATIONAL SEARCH REPORT

Application No

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